

Date: Tuesday, 23/12/2008 1:22:49 PM
 User: Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	WINDOW ASSEMBLY
Job Number :	44297		
Estimate Number :	10758		
P.O. Number :		Part Number :	D3136041
This Issue :	23/12/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3136 REV E
First Issue :	/ /	Project Number :	N/A
Previous Run :	37436	Drawing Revision :	E
	Type :	Material :	
	THERMOFORMING	Due Date :	12/01/2009
Written By :			Qty: 4 Um: Each
Checked & Approved By :			
Comment :	Est B 04.02.04 Reformat KJ/DS Est C Thermoform in house 05/07/2007 DL Est D Rev E 07.09.28 EC verified by: DD		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MACRLICS125	1/8" Polycast II Sheet
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Comment: Qty.: 4.4625 sf(s)/Unit Total : 17.8500 sf(s)
 polycast II or plexiglass G .125"

110115 HB 9-1-8

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------

**Comment:** FLOW WATER JETF
F
HB 9-1-8

(4)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

HB 9-1-8

4.0	QC8	SECOND CHECK
-----	-----	--------------

**Comment:** SECOND CHECK

S 08/01/08

(x4)

5.0	THERMOFORMING	THERMOFORMING MACHINE
-----	---------------	-----------------------

**Comment:** 1-Thermoform as per Dwg D3136 and Folio FTA006

Dwg Rev. E

Folio Rev. E

2- Engrave Part # and Batch # , and affix labels
 (D3136-1)

HB 09/02/12 X4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: WINDOW ASSEMBLY

Job Number: 44297

Part Number: D3136041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Check product for scratches mal-formation or any other non conformance.

BB 09/02/12 (X4)

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

S 09/02/12 (X4)

8.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

Water sand and buff to remove scratches as required

BB 09/02/12 (X4)

9.0

D31089

Decal



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part# Description Batch

2 D3108-9 Decal 34554

BB 09/02/12 (X4)

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/02/12 (X4)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

St 215 Reg 13 (4)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/17 JF

Job Completion



JF 09-02-13

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Page 1 of 1

Prototype

Comments

1

Approved

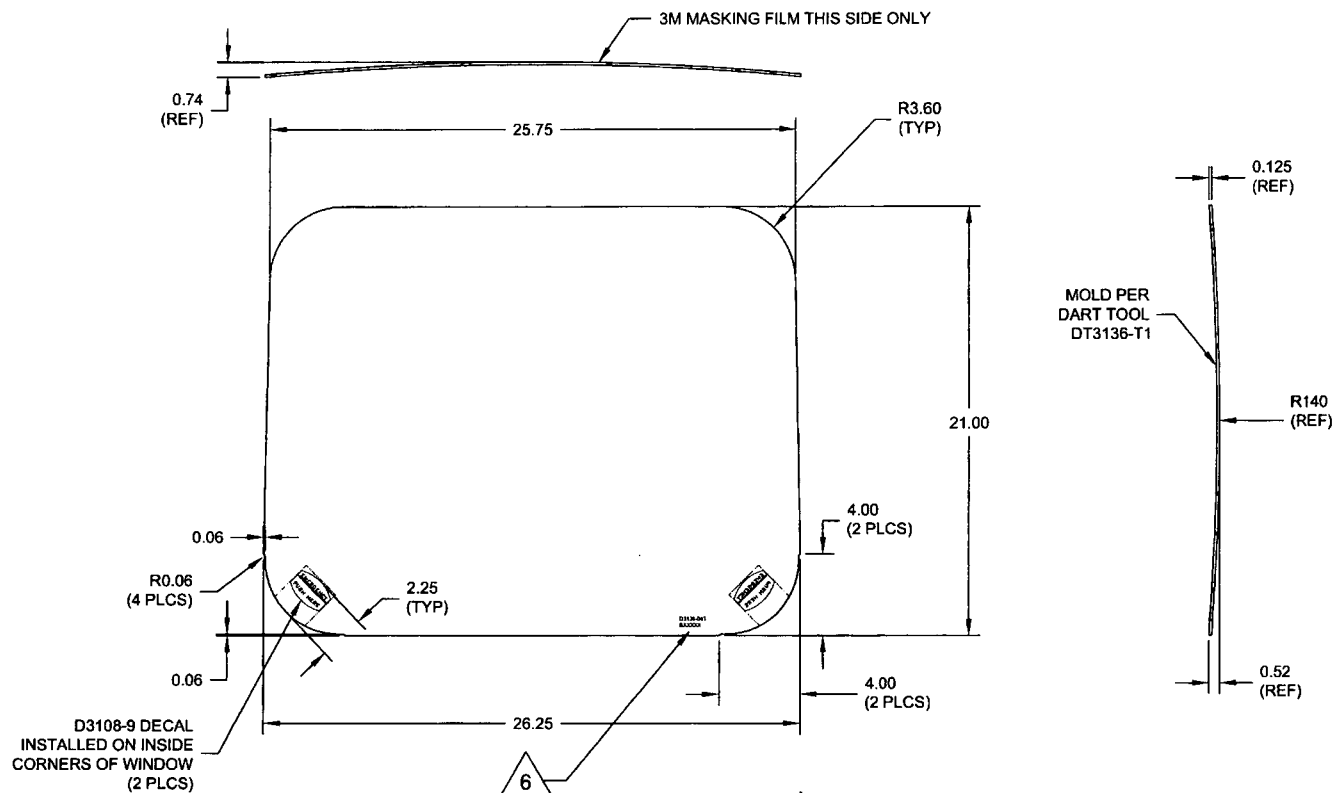
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries



D3136-3 WINDOW
D3136-043 WINDOW ASSEMBLY
 (INCLUDES D3108-9 DECALS)

NOTES:

- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425 OR PLEXIGLAS G
 CLEAR CAST ACRYLIC SHEET PER LP-391 TYPE 1 GRADE C, 0.125 THICK
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) REMOVE SHARP EDGES
- 6) IDENTIFICATION: ENGRAVE P/N "D3136-043" AND B/N ON LOWER EDGE
 USE 0.125" HIGH LETTERS TO MAXIMUM DEPTH OF 0.005"
- 7) WEIGHT: 2.61 +/- 0.58 LBS
- 8) FORMING PROCESS: a) HEAT LARGER PIECE TO 250° F
 b) DRAPE OVER D3136-T1 MOLD & CLAMP
 c) LEAVE FOR 2 HOURS COVERED WITH INSULATED BLANKETS

RELEASED
 07.09.22

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3136	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		WINDOW ASSEMBLY	1:
DATE	07.09.10	COPYRIGHT © 2002 BY DART AEROSPACE LTD	
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